

# Work Order ID 72586

Tuesday, August 02, 2011 2:38:36 PM



Page 1

Item ID: D2893-1

Accept



Setup Start



Revision ID:

(4)

Stop



Item Name: 2.75 Support

Start Date: 8/2/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 24.00



Customer:

Reference: ECN11-614

Approvals: Process Plan: *h*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2893

Rev *h* *ECN11-614*

50

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

PULL FROM STOCK:  
23 X D2893-1 B70478  
1 X D2893-1 B70736

FOR THE ENTIRE INNER CONCAVE SURFACE:  
~ ABRADEN SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE  
WITH MEK  
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M  
SCOTCH-WELD 2216 BfA  
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR  
24 HOURS.

*BT 11-08-03*

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

*Subsby*

*(X6)*

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Stop



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Start Date: 8/2/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 24.00



Customer:

Reference: ECN11-614

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

F70



Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

RE-IDENTIFY USING NEW B/N

④

11-08-10

F80



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

CK 11/08/10

MF  
11-08-10

# Picklist Print

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Work Order ID: 72586

Parent Item: D2893-1

Parent Item Name: 2.75 Support



Start Date: 8/2/2011



Required Date: 8/2/2011

Start Qty: 24.00

Required Qty: 24.00

## Comments:

IPP: C 02.11.26 Reformat; Added P/O KJ  
IPP D 06.04.19 removed alodine EC  
IPP Rev:E Added priming as per Rev B 07-04-30 JLM  
IPP F 08.03.19 Re-format EC verified by: DD  
IPP Rev:G 08-05-15 add QC14 DD verified by:EC

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit   | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| D2893-1<br> |                        | Manufactured  | No          |                     |                  |                 | Each               | 0.0000         |   | 24           |               |                |        |
| 2.75 Support   |                        |               |             |                     |                  |                 |                    |                |  |              |               |                |        |

23x B70478  
1x B70736

(see RT  
step 150)

## List Lots

Tuesday, August 02, 2011 2:03:04 PM

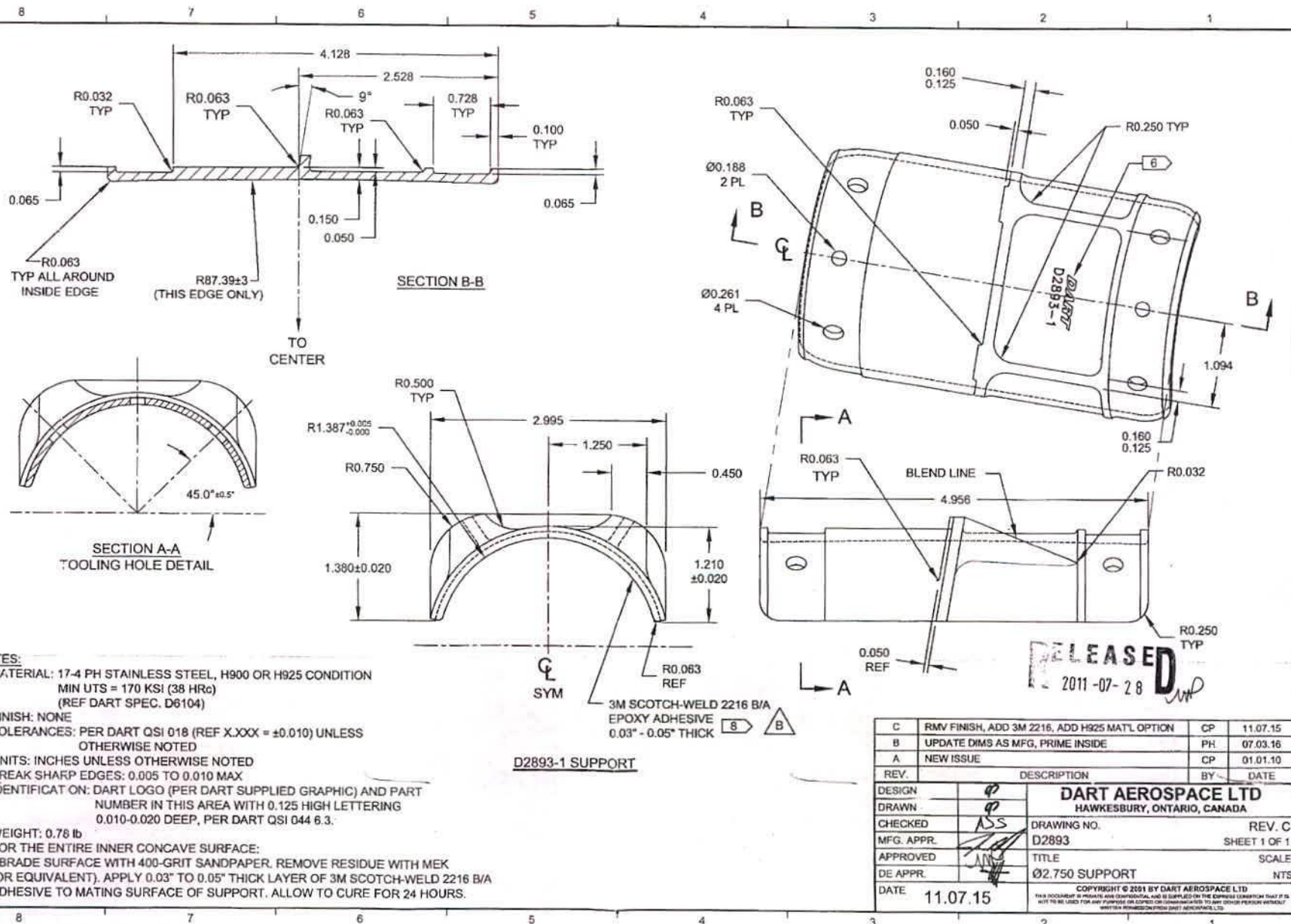
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Criteria : Item ID: d2893-1 All Locations All Warehouses All Quantity

| Item ID<br>Item Name    | Warehouse ID<br>Location ID | Lot Number | Last Trans Date | Lot Qty | Shelf Life Dt<br>Lot Code | Type Code | Comments |
|-------------------------|-----------------------------|------------|-----------------|---------|---------------------------|-----------|----------|
| D2893-1<br>2.75 Support | Main Warehouse<br>LG        | 70478      | 8/2/2011        | 23.0000 | QC21                      |           |          |
|                         | Main Warehouse<br>LG052     | 70736      | 8/2/2011        | 1.0000  | QC21                      |           |          |
| Total:                  |                             |            |                 | 24.0000 |                           |           |          |

*\$2506*





- NOTES:
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRc)  
(REF DART SPEC. D6104)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING  
0.010-0.020 DEEP, PER DART QSI 044 6.3.
  - 7) WEIGHT: 0.78 lb
  - 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2893-1 SUPPORT

|            |   |    |          |
|------------|---|----|----------|
| C          | RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION | CP | 11.07.15 |
| B          | UPDATE DIMS AS MFG, PRIME INSIDE              | PH | 07.03.16 |
| A          | NEW ISSUE                                     | CP | 01.01.10 |
| REV.       | DESCRIPTION                                   | BY | DATE     |
| DESIGN     | <i>P</i>                                      |    |          |
| DRAWN      | <i>P</i>                                      |    |          |
| CHECKED    | <i>ASS</i>                                    |    |          |
| MFG. APPR. | <i>ASS</i>                                    |    |          |
| APPROVED   | <i>ASS</i>                                    |    |          |
| DE APPR.   | <i>ASS</i>                                    |    |          |
| DATE       | 11.07.15                                      |    |          |

|   |                        |
|---|------------------------|
| DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| DRAWING NO.<br>D2893                              | REV. C<br>SHEET 1 OF 1 |
| TITLE<br>Ø2.750 SUPPORT                           | SCALE<br>NTS           |

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